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D206-802-032
Job Sheet 182564



Part No: D206-802-032

Job Qty: 1 ea

Part Name: Passenger Door Opener RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/28/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG IIN D206-802-3 REV A, DSI9579 REV B IPP Rev:A 10.12.03 as per dwg rev.A DD verf:EC IPP Rev:B 11.10.25 AS PER DSI9579 REV.A DD verf:EC IPP Rev:C 11.12.19 PER DSI9579 REV B DD verf:EC IPP Rev:D 12.07.30 AS PER ECN12-624 DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Stores/Pkg-1		AUG 30 2018
105	Packaging	1 pcs	9/7/18	9/7/18	0.00	0.00	Packaging1-3		
110	QC	1 pcs	9/7/18	9/7/18	0.00	0.00	QC4		
115	DC	1 pcs	9/7/18	9/7/18	0.00	0.00	DC		
120	Packaging	1 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-1		
130	QC21-FG	1 Ea	9/7/18	9/7/18	0.00	0.00	QC21		

Part Op 115 - Photocopy bluefile and create labels per PPP D206-802-032 CHG004
Descriptions: 120 - Identify and pack for shipping as per PPPDD206-802-032

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CR3523-4-4	Rivet	4 Ea (4 ea)	90-Start up Operation	5038755
D3552-17	Door Prop	1 Ea (1 ea)	90-Start up Operation	5046606
D3552-27	Door Prop	1 Ea (1 ea)	90-Start up Operation	5109255
D3622-5	Ball Stud	2 Ea (2 ea)	90-Start up Operation	5108819
D4108-047	Sill Doubler Assembly	1 Ea (1 ea)	90-Start up Operation	F133749
D4108-11	Template	1 Ea (1 ea)	90-Start up Operation	F85048
D4112-1	Aft Sill Doubler	1 Ea (1 ea)	90-Start up Operation	5008621
D4115-5	Doubler	1 Ea (1 ea)	90-Start up Operation	F148106
MS20426AD4-5	Rivet	4 Ea (4 ea)	90-Start up Operation	5083538
MS20600-AD4W2	Rivet	14 Ea (14 ea)	90-Start up Operation	5095301
MS21073L5	Anchor Nut	2 Ea (2 ea)	90-Start up Operation	5083550
NAS1149C0532R	Washer	6 Ea (6 ea)	90-Start up Operation	5089242
NAS1149C0563R	Washer	6 Ea (6 ea)	90-Start up Operation	5060989

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	CR3523-4-4	4	97	0
	D3552-17	1	5	0
	D3552-27	1	0	0
	D3622-5	2	0	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description Wo _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td style="width:15%;">Skid-tube</td> <td style="width:15%;">Cross tube</td> <td style="width:15%;">Water Jet</td> <td style="width:15%;">Engineering</td> </tr> <tr> <td>Machining</td> <td>Small Fab</td> <td>Prod. Eng. Coord.</td> <td>Quality</td> </tr> <tr> <td>Thermoforming</td> <td>Finishing</td> <td>Rec/Store/Packaging</td> <td>Other</td> </tr> <tr> <td>Large Fab</td> <td>Composite</td> <td>Supplier</td> <td></td> </tr> </table>			Skid-tube	Cross tube	Water Jet	Engineering	Machining	Small Fab	Prod. Eng. Coord.	Quality	Thermoforming	Finishing	Rec/Store/Packaging	Other	Large Fab	Composite	Supplier	
Skid-tube	Cross tube	Water Jet	Engineering																	
Machining	Small Fab	Prod. Eng. Coord.	Quality																	
Thermoforming	Finishing	Rec/Store/Packaging	Other																	
Large Fab	Composite	Supplier																		
		MRB (QSI042) Approval																		
		Completed By																		
		Lead hand / Supervisor Approval Verification																		
		QC / QA Coordinator Approval																		

DART AEROSPACE
 Container No: S106966
 Job No: D206-802-032
 Serial No/Batch: 182564
 Revision: S106966
 Inspector:
 Exp Date:
 Instructions: TC STC SH10-44 Issue Date: Feb 14/15
 FAS/STC SR029331

Root Cause			
Environment	No Re-ver		
Design	Operator		
Doc/Data	Offset/Setup		
Equip/Tooling	Supplier		
Handling/Pre	Training		
Material	Use for Testing		
Internal Transport	Poor Information		
Tribal Knowledge	Rushing		
LOA	Product Improvement		
Substation	Process Improvement		
Past Expiry Date	Manufacturing Process		
Misidentified	Past Due		
OTHER :			

☐ Positioned Wrong
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Drawing
☐ Finish
☐ Misread
☐ Turning Sequence

D4108-047	1	1	0
D4108-11	1	3	0
D4112-1	1	7	0
D4115-5	1	10	0
MS20426AD4-5	4	2,122	0
MS20600-AD4W2	14	224	0
MS21073L5	2	26	0
NAS1149C0532R	6	307	0
NAS1149C0563R	6	388	0

Part Specifications

Specifications could not be found.

Plex 8/28/18 10:44 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatte. ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

5.0 PARTS LIST**5.1 D206-802-029/-030 Crew Door Opener Kits**

Qty -029	Qty -030	Part Number	Description
		D206-802-029	CREW DOOR OPENER KIT, LH
		D206-802-030	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP
1	1	D3622-5	BALL STUD
1	1	D4110-3	DOUBLER, SILL
1		D4114-1	DOOR DOUBLER, LH
	1	D4114-2	DOOR DOUBLER, RH
4	4	MS20426AD4-5	RIVET
32	32	MS20600AD4W2	RIVET
2	2	MS21073L5	ANCHOR NUT
1	1	MS27130-A26	RIVNUT
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

5.2 D206-802-031/-032 Passenger Door Opener Kits

Qty -031	Qty -032	Part Number	Description
		D206-802-031	PASSENGER DOOR OPENER KIT, LH
		D206-802-032	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	2	D3622-5	BALL STUD
	1	D4112-1	AFT SILL DOUBLER
1	1	D4115-5	DOUBLER
1		D4115-041	LITTER DOOR BRACKET ASSY
3		CR3242-5-4	RIVET
2		CR3243-5-4	RIVET
2	4	MS20426AD4-5	RIVET
9	14	MS20600AD4W2	RIVET
1	2	MS21073L5	ANCHOR NUT
3	6	NAS1149C0532R	WASHER
3	6	NAS1149C0563R	WASHER

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-802-3 Rev. A AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D407-802 REV. 0
REF CANADIAN STC: SH10-44
REF FAA STC: SR02933NY
REF EASA STC: 10033253

1.0 PURPOSE:

It has come to Dart's attention that a portion of the airframe on recent Bell 206L4 aircraft is made of composite. In such cases, installing the D4112-1 (ref. D206-802-032 Kit) per IIN-D206-802-3 might not be possible. To that effect, Dart has created DSI 9579-011 Upgrade Kit to facilitate installation of D206-802-032 Kits at Change 001. The parts list of D206-802-032 Kits at Change 002 and later is amended as follows:

2.0 PARTS LIST CHANGE:

5.2 D206-802-031/-032 Passenger Door Opener Kits (IIN-D206-802-3 Rev. A)
52.4.9 D206-802-031/-032 Passenger Door Opener Kits (ICA-D407-802 Rev. 0)

Qty -031	Qty -032	Part Number	Description
		D206-802-031	PASSENGER DOOR OPENER KIT, LH
		D206-802-032	PASSENGER DOOR OPENER KIT, RH

ADD:

1	D4108-11	TEMPLATE
1	D4108-047	SILL DOUBLER ASSEMBLY
4	CR3523-4-4	RIVET
1	D3552-27	DOOR PROP

3.0 DSI-9579-011 UPGRADE KIT PARTS LIST:

Qty -011	Part Number	Description
	DSI 9579-011	UPGRADE KIT
1	D4108-11	TEMPLATE
1	D4108-047	SILL DOUBLER ASSEMBLY
4	CR3523-4-4	RIVET
1	D3552-27	DOOR PROP

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-0-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 11.12.07
CERT. NO.: SH10-44
ISSUE NO.: 1

B	ADD DOOR PROP D3552-27	AP	11.12.07
A	NEW ISSUE	MB	11.10.14
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9579	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		UPGRADE KIT	NTS
DATE	11.12.07	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Change Record

PAGE 1 OF 1

Part Number: D206-802-032

Description: PASSENGER DOOR OPENER, RH

[illegible]